

Work Order ID 134851***134851***

Page 1

Wednesday, July 22, 2015 12:49:51 PM

Item ID: D6014-090

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: ALUMINUM EXTRUSION

Start Date: 7/22/2015 Start Qty: 60.00

60

Cust Item ID:

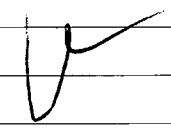
Required Date: 9/23/2015 Req'd Qty: 60.00

60

Customer:

Reference:

Approvals:

Process Plan: 

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D6014

Rev A

100

0.00

100

Purchasing

Purchasing

PURCHASING

Memo

Issue P/O: 29242

a) Extrude as per Dwg D6014

b) Material: 7075-T73/T73510/T73511 (QQ-A-200/11) Seamless Aluminum Tube

c) Minimum ultimate tensile strength = 68 ksi

d) Minimum tensile yield strength = 57 ksi

Possible Supplier: Aluminum Works

Material cert's is required

EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS.

MUST BE WELL PACKAGE, IF NOT IT WILL BE REFUSE

4 15-07.22

Work Order ID 134851***134851***

Page 2

Wednesday, July 22, 2015 12:49:51 PM

Item ID: D6014-090 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: ALUMINUM EXTRUSION
Start Date: 7/22/2015 Start Qty: 60.00 ***60*** Cust Item ID:
Required Date: 9/23/2015 Req'd Qty: 60.00 ***60*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	Receive & Inspect for Damage & Mat'l Certs	0.00							
110									
Packaging	Memo	0.00							
Packaging	Ensure material certification is attached								
120	QC6- Inspect dimensions to drawing	0.00							
120									
QC	Memo	0.00							
Quality Control	Ensure Material certification comply to Dwg								
150	Identify as per dwg & Stock Location: LG003	0.00							
150									
Packaging	Memo	0.00							
Packaging	LOCATION : LG003								

30

001 10 2014

DAS
03
9-10DAS
9
9-89

(30)

15-10-20
15-10-15

30

φ

ann
15/10/20

Picklist Print

Page 1

Wednesday, July 22, 2015 12:49:50 PM

Work Order ID: 134851

134851

Parent Item: D6014-090

D6014-090

Parent Item Name: ALUMINUM EXTRUSION

Start Date: 7/22/2015

Required Date: 9/23/2015

Start Qty: 60.00

Required Qty: 60.00

Comments: IPP A05.08.31New issueKJ/JLM
remove handfinishing and qc3

IPP Rev:B 10.06.07

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D6014-090P

Purchased

No

110

Each

0.0000

1

60

D6014-090P

30

DAS

CS

9-00

Aluminum Extrusion

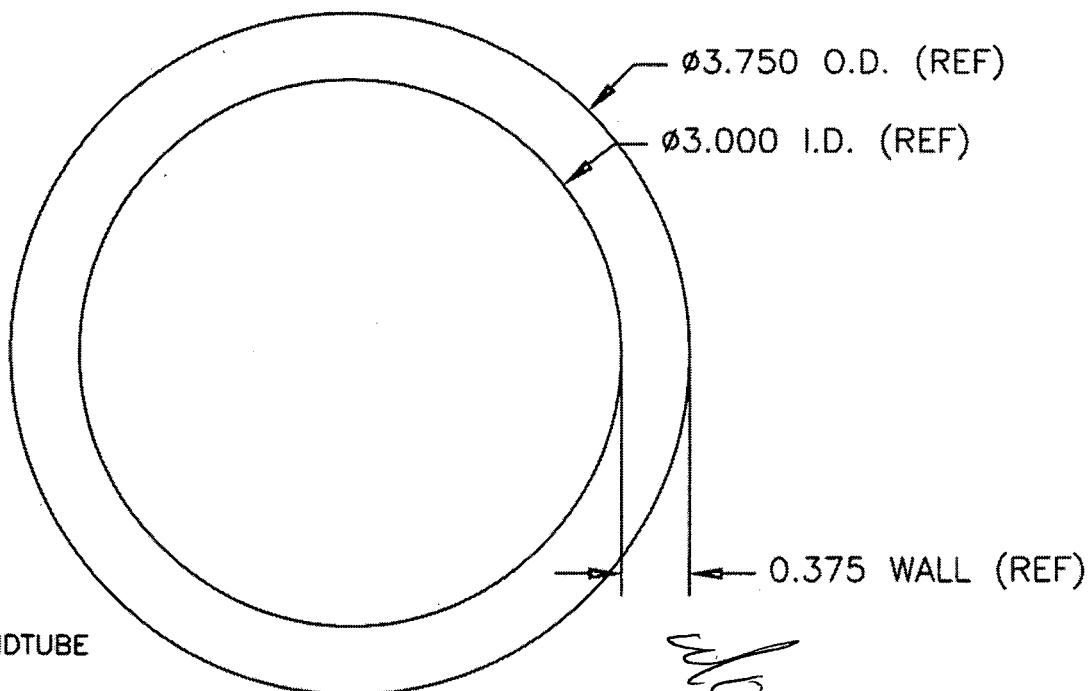
OCT 15 2015



DESIGN PH	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D6014	REV. A SHEET 1 OF 1
DATE 05.03.18		TITLE SKIDTUBE MATERIAL	SCALE 1:1
A	05.03.18	NEW ISSUE	

RELEASED
05-08-09 *[Signature]*

SPECIFICATION CONTROL DRAWING



NOTES

- 1) D6014-XXX SKIDTUBE
LENGTH

WHERE XXX IS LENGTH IN INCHES
EG. 64" LONG TUBE: D6014-064

- 2) MATERIAL: 3.750 OD x 0.375 WALL 7075-T73/T73510/T73511 PER QQ-A-200/11
SEAMLESS ALUMINUM TUBE.
MINIMUM ULTIMATE TENSILE STRENGTH = 68 ksi
MINIMUM YIELD TENSILE STRENGTH = 57 ksi
- 3) TOLERANCES ARE PER ASTM B210 AS FOLLOWS:
O.D.: ± 0.008 MEAN (± 0.016 INCLUDING OVALITY)
WALL: ± 0.015 MEAN (± 0.038 INCLUDING ECCENTRICITY)
LENGTH: XXX $+0.188/-0.000$
STRAIGHTNESS: 0.010" DEVIATION / 12" LENGTH
- 4) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 5) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO29242**

Purchase Order Date 7/22/2015

PO Print Date 7/23/2015

Page Number 1 of 2

Order From :

VU-ALU001

Ship To : DART AEROSPACE LTD

ALUMINIUMWERK UNNA AG
630 3033 SOUTH PARKER RD
AURORA, CO 80014
USA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 303 755 5672

Buyer

Linda Lacelle

Customer POID

Customer Tax # 10127-2607

Ship To Contact

Terms

Wire

Ship To Phone

Currency

USD

Ship Via:

Contract Shipping

FOB

DDP - (Delivered Duty Paid)

Ship Acct:

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D6014-090P	Aluminum Extrusion	9/23/2015 Yes 9/23/2015		30.00 Each	\$591.00	\$17,730.00
	a) Extrude as per Dwg D6014 b) Material: 7075T73/T73510/T73511 (QQ-A-200/11)Seamless Aluminum Tube c) Minimum ultimate tensile strength = 68 ksi d) Minimum tensile yield strength = 57 ksi						
						Line Total:	\$17,730.00
2	71401-45	Procurement Quality Clause	9/23/2015 No 9/23/2015		1.00	\$0.00	\$0.00
	Procurement Quality Clauses A005 right of entry A012 chemical and physical test report A016 personnel qualification A017 raw material identification (as applicable) A026 certification of material conformance A041 quality management system A042 dart notification by supplier A043 retention of quality documents						

Note:

7/23/2015

Abnahmeprüfzeugnis 3.1 - DIN EN 10204:2005

Inspection Certificate 3.1 - DIN EN 10204:2005 / Certificat de Reception 3.1- DIN EN 10204:2005

Kunde: Dart Aerospace Ltd.
Client:

1270 Aberdeen Street
K6A1K7 Hawkesbury, ON Canada

Zeugnisnummer: 1349/15

Cert No.: / No. du certificat:

Bestellnummer:

Order No. / No. de commande

Auftrag:

57937/100

Our Reference/Notre Reference:

Produkt:

Product / Produit:

Spezifikation:

Specification:

Werkstoff:

Alloy/Alliage:

Abmessung

Size / Dimension

Kennzeichnung

Marking/Marquage:

7075

Zustand:

Temper/État

T 73511

DAS

9

9-89

3,750 INCH x 3,000 INCH x 0,375 INCH x 90,000 INCH

D6014-090

CERT. NO. 1349/15 - ALUnna - 7075 - T73511 - CAST NO. 3572 - AMS - QQ - A - 200/11(A) - 3.750"OD X 0.375"WALL - HEAT LOT NO. 1304832 - ALUNNA ORDER CONF. NO. 57937/100 - 1 - P.O. 29242

Lieferung

Delivered Material / Matériel délivré:

pcs.

lbs

Country of Manufacture: Germany

30

1100

Products are in accordance with applicable RoHS

1. Chemische Analyse

Chemical Analysis / analyse chimique

	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Pb	Zr	Bi	Sn	Ni	Na
Charge/ min.			1,2		2,1	0,18	5,1							
Cast No. max.	0,40	0,50	2,0	0,30	2,9	0,28	6,1	0,20						
3572/15	0,098	0,178	1,490	0,044	2,424	0,210	5,838	0,042	0,002	0,0235	0,0001	0,0014	0,0063	0,0002

Hydrogen content: 0,12

ccm/100 g Al Elements without indication < 0,01 %

country of melt manufacturer: Germany

2. Mechanische Eigenschaften

Mechanical Properties / Valeurs Mécaniques

Anforderungen Requirements	tensile (Rm) ksi	yield (Rp0,2) ksi	elongation 2" %	elongation A %	Hardness HB	RMS 25 / Ra max. 0,58 µm
	68,0	57,0	8,0			
1	79,025	69,890	9,0			max. 12,0 µ"
2	78,880	69,890	9,0			

Ergebnis der Prüfungen:

Es wird bestätigt, daß die Lieferung geprüft wurde und den Vereinbarungen bei der Bestellannahme entspricht

Test results:

We confirm that the delivery has been tested and applies to the agreements made on receipt of the order

Resultats:

Nous confirmons que la livraison a été contrôlée et correspond avec les conventions faites à la réception de la commande

mergardtri



Certified acc. DIN EN ISO 9001:2008 and DIN EN 9100:2009

valid until 2016-11-10

Cert.-Req. No.: 001959 QM08; 001959 ASH 09-1

11.09.2015

Aluminiumwerk Unna AG, Uelzener Weg 36, 59425 Unna, Germany



ALUnna

Abnahmebeauftragter

Kuehne + Nagel

3148 lambert
Ste-Marthe sur le lac, QC
J0N 1P0
(514) 636-0758

Date		# BOL	# Ref.
07/10/2015		35389	21658651003400
Pickup Location / Lieu de collecte		Delivery Location / Lieu de livraison	
LAFRANCE WAREHOUSE 7055 NOTRE DAME EST MONTREAL, QC H1N 3R8 Tel: 514-254-6688 <i>805 EXUL 217 292</i>		Dart Aerospace 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 Sue Bedford Tel: 613-632-5200	
Pieces and Weight / Morceaux et poids		Other informations / Autre informations	
2 pieces / 2 crates / 705 kg / 0 x 0 x 0 cm			
Informations			
CC# 8041 1004667414			
First and Last Name / Nom et prénom		Date and Time / Date et heure	
Signed / Signature			

KUEHNE+NAGEL**CUSTOMS ACROSS SYSTEM RELEASE NOTIFICATION TRANSACTION DETAIL**

3510 Boulevard St-Laurent Suite 400 Montreal, QC H2X 2V2 Tel: 514-397-9900 Fax: 5143970400		File No/No de Dossier 21658651003400		Account No/No de Compte D414603	
For Official Use/Usage Officielle Customs Released/Mainlevé Douanière via RNS 07-Oct-2015 12:05		Transaction No/No de Transaction 13284631253652			
		Importer No/No de L'importateur 101272607RM0001		Invoice Of/Facture de	
		Importer Name/Nom de L'importateur DART AEROSPACE LTD			
Customs Office/Bureau de Douanes 0395 MONTREAL - MAIN, QC		Bill of Lading No/No de Connaissance		Client Reference/Référence Client PO29242	
Location of Goods/Emplacement de la Marchandise ENTREPOTS LAFRANCE I		Carrier/Transporteur SHIPCO TRANSPORT CA			
Quantity/ Quantité de Pièces 000000002		Cargo Control No/ No de contrôle Fret 805EYUL217292		Bonded Warehouse Number/ Nombre d'entrepôt sous douane	
Container Number/Numéro du conteneur OOLU8750143		Documents Received/Documents Recus Master Bill No: House Bill No: Sub House Bill No:			
		Vishal Bahadoor 07-Oct-2015			



Shipco Transport (Canada) Inc.

10500 Cote de Liesse, Suite # 230

Lachine, Quebec H8T 1A4, Canada

Telephone: +1 514 631 3611 | Telefax: +1 514 631 1320 | Email: mon.imp.lcl.cust@shipco.com | Website: www.shipco.com

By Heawon Shin

05 Oct, 2015 10:55 AM EDT

Page Number 1 of 1

Canada Customs Cargo Control Document

References

Reference Number
151019505909

Cargo Control / N° De Controle Du
Number / Fret



805EYUL217292

Previous Cargo / N° De Controle Du
Control Number / Fret Anterieur
90822565141870

Manifest / Manifeste
From / De
0395 MONTRÉAL

Manifest / Manifeste
To / A
0395 MONTRÉAL

Routing

Foreign Point / Point De Chargement Vessel / Voyage
of Loading / Etranger
HAMBURG OOCL MONTREAL /
68W40

ETA
05 OCT, 2015

Advice Date
05 OCTOBER 2015

Vehicle / Identification
Identification / Du Vehicule

Acquit / N° De
Number / L'Acquittement

Container / N° De Con
Number / Teneur
OOLU8750143

Seal
Number
WWA0134182

Carrier / Nom Du
Name / Transporter
OOCL

Cargo

Total Pieces

2

Total Weight / Poids

1554.259 Lbs
705 Kg

Total Volume

92.171 Cbf
2.61 Cbm

Qty Shown On Manifest

2

Qty Cleared Under This Entry

2

Shipment Details

Contacts

Consignee / Destinataire
SENATOR INTERNATIONAL
FREIGHT FORWARDING LLC
76 SOUTH WOODS PARKWAY
SUITE 200
US 30354 ATLANTA, GA

Shipper / L'Expéditeur
SENATOR INTERNATIONAL
SPEDITION GMBH
OBENHAUPTSTRASSE 13
22335 HAMBURG
GERMANY

Reason Of Change :

Location Of Goods / Emplacement Des Marchandises

ENTREPOTS LAFRANCE - SUB LOC
2467/PARS
WWW.LAFRANCE.QC.CA 7055 NOTRE-
DAME E.
TEL:514-254-6688 FAX 514-254-0825
MONTREAL QUEBEC H1N 3R8 CANADA
1-514-254-6688
MANOND@LAFRANCE.QC.CA

Marks & Numbers

DART AEROSPACE CRATES (1 BUNDLE) ALUMINIUM
LTD TUBES
1270 ABERDEEN
STREET
HAWKESBURY ON FREIGHT PREPAID
20000
CANADA
REF.: 10942
YUL217292

Instructions

THE ABOVE SHIPMENT IS HELD ON BOND AT RISK AND EXPENSE OF OWNER'S AGENT. ACCEPTANCE OF ADVICE NOTE FOR CUSTOMS CLEARANCE AND RELEASE OF GOODS CONSTITUTES YOUR ACCEPTANCE OF LIABILITY FOR ABOVE CHARGES AND STORAGE, IF ANY, AFTER FREE TIME HAS EXPIRED.



Shipco Transport (Canada) Inc. RELEASE ORDER

SHIPPER SENATOR INTERNATIONAL SPEDITION GMBH OBENHAUPTSTRASSE 13 22335 HAMBURG GERMANY		INVOICE NO.	HOUSE BILL OF LADING NO. YUL217292					
		COMMENTS AMS HB/L NO: YUL217292	REFERENCE NO. 151019505909					
CONSIGNEE SENATOR INTERNATIONAL FREIGHT FORWARDING LLC 76 SOUTH WOODS PARKWAY SUITE 200 US 30354 ATLANTA, GA		FOR DELIVERY PLEASE APPLY TO SHIPCO TRANSPORT (CANADA) INC. 10500 COTE DE LIESSE, SUITE # 230 LACHINE, QUEBEC CANADA H8T 1A4 TEL: +1 514 631 3611 FAX: +1 514 631 1320						
NOTIFY PARTY SENATOR INTERNATIONAL FREIGHT IMPORTS@ORD.SENATOR-INTERNATIONAL.COM 1003 HAWTHORN DRIVE ITASCA, IL 60143		FREIGHT LOCATION ENTREPOTS LAFRANCE - SUB LOC 2467/PARS WWW.LAFRANCE.QC.CA 7055 NOTRE-DAME E. TEL: 514-254-6688 FAX 514-254-0825 MONTREAL QUEBEC H1N 3R8 CANADA 1-514-254-6688 MANOND@LAFRANCE.QC.CA						
LINE BILL OF LADING OOLU2565141870	CONTAINER NO. OOLU8750143							
VESSEL/VOY # OOCL MONTREAL 68W40	PORT OF LOADING HAMBURG	ETD SEP/27						
PORT OF DISCHARGE MONTREAL	ETA 05-OCT-2015	PLACE OF DELIVERY MONTREAL, FOT	ETA OCT/05					
<table border="1"><tr><td>DATE AVAILABLE</td><td>07-OCT-2015</td><td>FREE TIME EXPIRES</td><td>5</td><td>CALENDAR DAYS</td></tr></table>				DATE AVAILABLE	07-OCT-2015	FREE TIME EXPIRES	5	CALENDAR DAYS
DATE AVAILABLE	07-OCT-2015	FREE TIME EXPIRES	5	CALENDAR DAYS				

PARTICULARS FURNISHED BY SHIPPER

MARKS & NOS/CONTAINER NOS	NO. OF PKGS	DESCRIPTION OF PACKAGES AND GOODS	GROSS WEIGHT	MEASUREMENT
DART AEROSPACE LTD 1270 ABERDEEN STREET HAWKESBURY ON 20000 CANADA REF.: 10942 YUL217292	2	CRATES (1 BUNDLE) ALUMINIUM TUBES FREIGHT PREPAID	705.000 KGS 1554.259 LBS	2.610 CBM 92.171 CBF
PLEASE VERIFY CARGO IS IN WAREHOUSE PRIOR TO SUBMITTING MANIFESTS. PRE-ALERT ONLY, MANIFESTS WILL BE FAXED ONCE CARGO AVAILABLE INTO THE WAREHOUSE. IF A SPLIT IS REQUIRED PLEASE CONTACT LOCAL STI-OFFICE FOR CC# OR SPLIT CHARGES MAY APPLY. REGARDS, HEAWON - HSHIN@SHIPCO.COM				

I.T. INFORMATION	I.T. NUMBER	DATE OF I.T.	PORT OF I.T. NULL
------------------	-------------	--------------	----------------------

ENTREPOTS LAFRANCE - SUB LOC 2467/PARS
WWW.LAFRANCE.QC.CA 7055 NOTRE-DAME E.
TEL: 514-254-6688 FAX 514-254-0825
MONTREAL QUEBEC H1N 3R8 CANADA
1-514-254-6688

This document is an original delivery order and the only delivery order produced to cover the release of this merchandise. It is valid when it contains an original signature.

KUEHNE+NAGEL



MONTREAL, QUEBEC H3B 3A7

Phone: 514-397-9900

Fax: 514-397-0400

DELIVERY INSTRUCTION / TERMINAL NOTIFICATION

From: Vishal Bahadoor Ext. 3175 Date: Oct. 07, 2015

To: LAFRANCE WHSE #: _____

Importer: Dart Aerospace

Cargo Control #: 8041 1004667414

Vessel: _____

Total Quantity: 2 PKGS Total Weight: 705 kgs Total Containers: _____

	Container Number	Type	Pick Up #:	Pcs.	Weight	CBM
1	OOLU8750143					
2						
3						
4						
5						
6						

Goods on Hand at: 2467- LAFRANCE

Delivery By: CAMIONAIR

Delivery to: _____

Contact at point of delivery: _____

Dart Aerospace.
1270 Aberdeen St
Hawkesbyry, ON
K6A 1K7

Special Instructions: _____

Last Free Day: _____

Prepaid/Collect: _____ KN Reference #: 21658651003400

PLEASE ACCEPT THIS AS A GUARANTEE FOR THE ABOVE NOTED SHIPMENT

Dock Charge: _____

Storage: _____

Demurrage: _____

Customs Inspection: _____

Guarantee of: _____

Signature: VISHAL BAHADOOR

Date: 10/07/2015

KUEHNE+NAGEL



MONTREAL, QUEBEC H3B 3A7

Phone: 514-397-9900

Fax: 514-397-0400

DELIVERY INSTRUCTION / TERMINAL NOTIFICATION

From: Vishal Bahadoor Ext. 3175 Date: Oct. 07, 2015

To: LAFRANCE WHSE #: _____

Importer: Dart Aerospace

Cargo Control #: 805EYUL217292

Vessel: _____

Total Quantity: 2 PKGS Total Weight: 705 kgs Total Containers: _____

	Container Number	Type	Pick Up #:	Pcs.	Weight	CBM
1	OOLU8750143					
2						
3						
4						
5						
6						

Goods on Hand at: 2467- LAFRANCE

Delivery By: CAMIONAIR

Delivery to: _____

Contact at point of delivery: _____

Dart Aerospace.
1270 Aberdeen St
Hawkesbyry, ON
K6A 1K7

Special Instructions: _____

Last Free Day: _____

Prepaid/Collect: _____

KN Reference #: 21658651003400

PLEASE ACCEPT THIS AS A GUARANTEE FOR THE ABOVE NOTED SHIPMENT

Dock Charge: _____

Storage: _____

Demurrage: _____

Customs Inspection: _____

Guarantee of: _____

Signature: VISHAL BAHADOOR

Date: 10/07/2015

Aluminiumwerk Unna AG · Uelzener Weg 36 · D-59425 Unna

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ONT, K6A1K7
Kanada

Aluminiumwerk Unna AG
Uelzener Weg 36 · D-59425 Unna
Postfach 11 46 · D-59401
fon +49 (0) 23 03-206 - 0
fax +49 (0) 23 03-206- 116
info@alunnatubes.com
www.alunnatubes.com

page: 1
date: 15.09.2015
customer: 40980

delivery note

89958

your PO dated: 22.07.2015
your PO No.: PO29242
confirmation No.: 57937

contact: Petra Eisenblätter
Tel.: +(303) 755 5672
Fax: +(303) 755 5936
representative: CLAUS J. BETTER

CARRIER: Senator International
Your VAT No.:
AWU VAT No.: DE177869055
Country of origin: Germany

We supply acc. to our delivery terms and conditions:

item	quantity	unit	net kgs
100	30,000	PC	

AWU article: 37351 / Tariff no. 76082081

Customer article: D6014-090 3.750 X 0.375 X 90 / cust. drwg.

product: Tubes / seamless extruded / EN AW-7075 / round

condition: T 73511 / AMS-QQ-A-200/11(A)

outer diameter:	3,750 INCH Tol.	+0,016	-0,016
tol. for mean OD		+0,008	-0,008
inner diameter:	3,000 INCH		
wall thickness:	0,375 INCH Tol.	+0,037	-0,037
fixed length	90,000 INCH Tol.	+0,188	

inspection cert. acc. to EN10204/3.1 / RM 469 / Rp0,2: 393

straightness 0,01 INCH / 1 FEET / RMS max.: outer 25

tol. on quantity +10 % -10 %

3.750" OD 0.375" Wall, 90" lengths

Part Number D6014-090 skidtube

Tolerances per ASTM B210

Outside surface: max. defects up to 0.005" (longitudinally)

Tubes protected with corrosion protective oil

Tubes line marked

Packing: seaworthy wooden cases

Commerzbank AG, Unna
Konto-Nr. 102 56 00 · BLZ 443 400 37
BIC/S.W.I.F.T. - Code: COBADE FF 443
IBAN: DE 90 4434 0037 01025600 00
Sitz der Gesellschaft: Unna
Amtsgericht Hamm, HRB 3045

delivery note**89958**

page: 2
date: 15.09.2015
customer 40980

number of packages: 2
number of pieces: 30
terms of delivery: DDP (Delivered, Duty, Paid)

weight:	gross	705,000	net	499,000
Packstücke	2			
customer address:				
DART AEROSPACE LTD.				
1270 Aberdeen Street				
HAWKESBURY ON K6A 1K7				
Kanada				

Aluminiumwerk Unna AG · Uelzener Weg 36 · D-59425 Unna

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ONT, K6A1K7
Kanada

Aluminiumwerk Unna AG
Uelzener Weg 36 · D-59425 Unna

Postfach 11 46 · D-59401
fon +49 (0) 23 03-206 - 0
fax +49 (0) 23 03-206- 116
info@alunnatubes.com
www.alunnatubes.com

page: 1
date: 15.09.2015
customer 40980

delivery note

89958

your PO dated: 22.07.2015
your PO No.: PO29242
confirmation No.: 57937

contact: Petra Eisenblätter
Tel.: +(303) 755 5672
Fax: +(303) 755 5936
representative: CLAUS J. BETTER

CARRIER: Senator International
Your VAT No.:
AWU VAT No.: DE177869055
Country of origin: Germany

We supply acc. to our delivery terms and conditions:

item	quantity	unit	net kgs
------	----------	------	---------

100	30,000	PC	
-----	--------	----	--

AWU article: 37351 / Tariff no. 76082081

Customer article: D6014-090 3.750 X 0.375 X 90 / cust. drwg.

product: Tubes / seamless extruded / EN AW-7075 / round

condition: T 73511 / AMS-QQ-A-200/11(A)

outer diameter:	3,750 INCH Tol.	+0,016	-0,016
-----------------	-----------------	--------	--------

tol. for mean OD		+0,008	-0,008
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inner diameter:	3,000 INCH		
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wall thickness:	0,375 INCH Tol.	+0,037	-0,037
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fixed length	90,000 INCH Tol.	+0,188	
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inspection cert. acc. to EN10204/3.1 / RM 469 / Rp0,2: 393

straightness 0,01 INCH / 1 FEET / RMS max.: outer 25

tol. on quantity +10 % -10 %

3.750" OD 0.375" Wall, 90" lengths

Part Number D6014-090 skidtube

Tolerances per ASTM B210

Outside surface: max. defects up to 0.005" (longitudinally)

Tubes protected with corrosion protective oil

Tubes line marked

Packing: seaworthy wooden cases

Commerzbank AG, Unna
Konto-Nr. 102 56 00 · BLZ 443 400 37
BIC/S.W.I.F.T. - Code: COBADE FF 443
IBAN: DE 90 4434 0037 01025600 00
Sitz der Gesellschaft: Unna
Amtsgericht Hamm, HRB 3045

delivery note**89958**

page: 2
date: 15.09.2015
customer 40980

number of packages: 2
number of pieces: 30
terms of delivery: DDP (Delivered, Duty, Paid)

weight:	gross	705,000	net	499,000
Packstücke	2			

customer address:

DART AEROSPACE LTD.
1270 Aberdeen Street
HAWKESBURY ON K6A 1K7
Kanada

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: D6014-090
 DATE: 15-10-20

PO / BATCH NO.: P029242/D134851

MATERIAL CERT REC'D: yes
 QUANTITY RECEIVED: 30
 QUANTITY INSPECTED: 30
 QUANTITY REJECTED: 0

THICKNESS ORDERED: .375
 THICKNESS RECEIVED: .375
 SHEET SIZE ORDERED: N/A
 SHEET SIZE RECEIVED: N/A

DESCRIPTION	NCR (Check Y/N)		COMMENTS
SURFACE DAMAGE	Y	(N)	
CORRECT FINISH	(Y)	N	
CORROSION	Y	(N)	
CORRECT GRAIN DIRECTION	(Y)	N	
CORRECT MATERIAL	(Y)	N	
CORRECT THICKNESS	(Y)	N	
PHOTO REQUIRED	Y	(N)	
CORRECT MATERIAL	(Y)	N	
CORRECT REF # TO LINK CERT	(Y)	N	<u>P029242</u>
CORRECT MATERIAL IDENTIFICATION	(Y)	N	<u>D6014-090</u>
CORRECT M# ON THE MATERIAL	(Y)	N	<u>B134851</u>
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y	(N)	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y	(N)	

CUT SAMPLE PIECE OF MATERIAL AND PREFORM A HARDNESS CHECK. RECORD RESULTS BELOW				
TYPE OF MATERIAL	HRC	HRB	DUR A	DUR D
SIZE OF TEST SAMPLE				
HARDNESS / DUROMETER READING				

testers located in the Quality Office

QC 18 INSPECTION	ENGINEERING SIGNOFF (if required)
INSPECTED BY: <u>9</u> <u>9-89</u>	SIGNED OFF BY: _____
DATE: <u>15-10-20</u>	DATE: _____

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in

MATERIAL RECEIPT INSPECTION FORM

INSTRUCTIONS FOR INSPECTING BAR, TUBING, ROUND, & SHEET STOCK

- 1- VERIFY STOCK TO DART PURCHASE ORDER
- 2- MEASURE ALL DIMENSIONS FOR EACH PURCHASED STOCK
 - a. WIDTH, THICKNESS, DIAMETER, WALL THICKNESS & LENGTH
- 3- VERIFY CONDITION OF MATERIAL i.e. DAMAGED, CORRODED, etc.
- 4- VERIFY THAT SUPPLIER HAS A NUMBER (HEAT #) ON ITS RECEIVING REPORT TO LINK TO MATERIAL CERTS
- 5- VERIFY MATERIAL CERTS ARE CORRECT TO THE DART PO INSTRUCTIONS
- 6- REMOVE / CUT A PIECE OF MATERIAL FOR SAMPLE HARDNESS TESTING

INSTRUCTIONS FOR INSPECTING SKIDTUBE & STEP EXTRUSION

- 1- VERIFY TO DART SUPPLIED DRAWING
- 2- SAMPLE INSPECT MATERIAL IN BUNDLE TO ENSURE MATERIAL CAN BE RECEIVED INTO DART
- 3- USING PORTABLE HARDNESS TESTER VERIFY HARDNESS OF THE MATERIAL TO THE DRAWING
- 4- VERIFY THAT MATERIAL CERTS MATCH TO WHATS CALLED UP ON THE DART DRAWING

AFTER MATERIAL PASSES INSPECTION

- 5- HAVE DART EMPLOYEES START STOCKING MATERIAL BUT REQUEST MIN 20pcs FOR FULL INSPECTION
- 6- INSPECT ALL DIMS AS PER DRAWING REQUIREMENTS

INSTRUCTIONS FOR INSPECTING CROSS TUBE MATERIAL

- 1- VERIFY MATERIAL CERTS MATCH THE REQUIREMENTS ON THE DART DRAWINGS
- 2- INSPECT MIN. HALF THE BATCH OF EXTRUSION RECEIVED INTO DART
- 3- INSPECT MATERIAL AS PER THE EXTRUSION REPORT
 - a. WALL THICKNESS USING ULTRA-SONIC IN 4 LOCATIONS
 - b. OUTSIDE DIAMETER HIGHEST/LOWEST BOTH ENDS
 - c. INSIDE DIAMETER HIGHEST/LOWEST BOTH ENDS
 - d. STRAIGHTNESS @ CENTER OVER 12" SPAN
 - e. WALL THICKNESS USING TUBE MICROMETER HIGHEST/LOWEST BOTH ENDS
- 4- IDENTIFY EACH TUBE IN SEQUENCE OF INSPECTING (TUBE 1, TUBE2.....) AND W/O# AND PO#
- 5- RECORD ALL FINDINGS ON EXTRUSION REPORT

IF ANY QUESTIONS PLEASE SEE QC COORDINATOR BEFORE GOING FURTHER